Pipeweld 6010 Plus

Cellulosic-coated electrode designed for welding of pipes and pipelines in all positions using conventional and stovepipe techniques. API 5L up to X56, root pass up to X80.

Classifications:	SFA/AWS A5.1:E6010, EN ISO 2560-A:E 38 2 C 21
Approvals:	LR 3, ABS 3

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+
Alloy Type:	Carbon - Manganese
Coating Type:	Cellulosic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As welded	480 MPa	590 MPa	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As welded	-20 °C	50 J
As welded	-29 °C	40 J

Typical Weld Metal Analysis %

C	Mn	Si
0.11	0.44	0.13

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 350 mm	40-75 A	34 V	0.79	100	54 s	0.7 kg/h
3.2 x 350 mm	60-125 A	25 V	0.69	67	57 s	1.0 kg/h
4.0 x 350 mm	80-180 A	30 V	0.63	50	58 s	1.2 kg/h
5.0 x 350 mm	120-230 A	28 V	0.71	29	65 s	1.9 kg/h